

Date: Thursday, 05/02/2009 3:42:27 PM  
 User: Julie Dawson

Black  
Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: ARM		
Job Number	: 45543					
Estimate Number	: 11969					
P.O. Number	:			Part Number	: D2065	
This Issue	: 05/02/2009		S.O. No.	: D2065 REV C		
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type	: SMALL /MED FAB		
Previous Run	: 41524			Drawing Revision	: C	
Written By	:			Material	:	
Checked & Approved By	: JWD 09-02-04			Due Date	: 20/02/2009	
Comment	: Est: E 02.04.15 Added Dwg Rev.B1NG			Qty:	10 Um: Each	
	: Est Rev:F 08-07-24 revC as per dwg (ecn 08-504) DD verified					
	by:EC					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0500W049	304 RD Tube .500 x .049W
		
	Comment: Qty.: 1.7063 f(s)/Unit Total : 17.0625 f(s) 304 RD Tube .500 x .049W Seamless Tube batch: M 108823	
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		
	Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Punch 1/2" OD x .049" Wall 304/316 SS as per Dwg D2065 (per D2727) using DT8012. Note: 1 end only 2-Cut to length as per Dwg D2065 3-Form as per Dwg D2065 and template DT8251 4-Drill 0.188" Dia holes as per Dwg D2065 using drill jig DT8779 and template DT8251 5-Deburr	
3.0	QC5	INSPECT WORK TO CURRENT STEP
		
	Comment: INSPECT WORK TO CURRENT STEP	
4.0	POWDER COATING	POWDER COATING
		
	Comment: POWDER COATING Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3	
	START TIME: 8:00AM OVEN TEMPERATURE: 320° FINISH TIME: 8:30AM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Description :

5.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(10)

BK 09-02-24

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST220

AS 09/02/25 (xc)  
09/02/25 (x)

7.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 09.02.25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

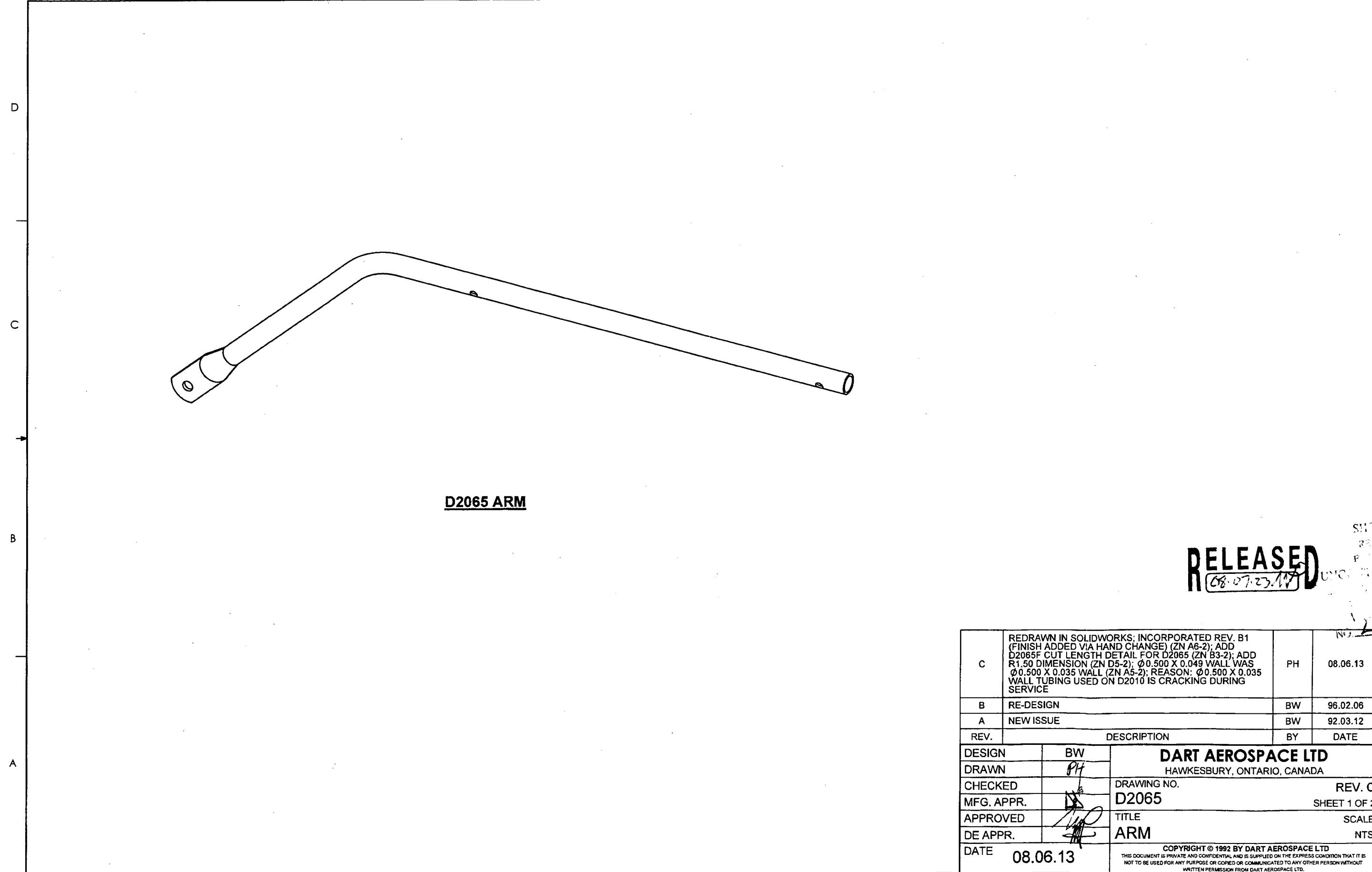
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D2065 ARM

C	REDRAWN IN SOLIDWORKS; INCORPORATED REV. B1 (FINISH ADDED VIA HAND CHANGE) (ZN A6-2); ADD D2065F CUT LENGTH DETAIL FOR D2065 (ZN B3-2); ADD R1.50 DIMENSION (ZN D5-2); Ø0.500 X 0.049 WALL WAS Ø0.500 X 0.035 WALL (ZN A5-2); REASON: Ø0.500 X 0.035 WALL TUBING USED ON D2010 IS CRACKING DURING SERVICE	PH	08.06.13
B	RE-DESIGN	BW	96.02.06
A	NEW ISSUE	BW	92.03.12
REV.	DESCRIPTION		BY DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH	DRAWING NO. <b>D2065</b>	
CHECKED	B	REV. C	
MFG. APPR.	DS	SHEET 1 OF 2	
APPROVED	AS	TITLE	
DE APPR.	AS	SCALE	
DATE	08.06.13	NTS	
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